

Work Order ID 60338

July 6, 2010 7:29:12 AM



PRELIMINARY ISSUE Page 1

Item ID: D4102-2

Revision ID: SHIM

Item Name:

Start Date: 07/07/2010 Start Qty: 2.00

Required Date: 28/07/2010 Req'd Qty: 2.00

Reference: Surf 10.07.06

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start



Stop



Cust Item ID:

Customer:



Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
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D4102 REV.PRELIM PAT

100 Cut blanks as per folio 0.00



Bandsaw Memo 0.00

Jespa Bandsaw 4.950" long

ark 10/07/09

2 0

110



HAAS 1

HAAS CNC vertical machine #1

Memo 0.00
MILL AS PER DWG AND FOLIO FA945
FOLIO REV: AA
DWG REV: PAT

ark / 88, 10/07/15

2 0

DEBURR

Work Order ID 60338

Page 2

July 6, 2010 7:29:12 AM

Item ID: D4102-2

Accept



Setup Start



Revision ID: SHIM

Stop



Item Name:

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

8/10/07/15

0.00

2

/

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Inspection to pay day only

0.00

10/07/15

62

/

140



HandFinish

Chemical Conversion Coat per QSI005 4.1

0.00

0.00

X2

/

10/07/19

/

Work Order ID 60338

Page 3

July 6, 2010 7:29:12 AM

Item ID: D4102-2

Accept



Setup Start



Revision ID: SHIM

Stop



Item Name:

Start Date: 07/07/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 28/07/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00

→ inspects to PA 4



QC

Memo

0.00

dry only

8/07/10

Quality Control

160

Identify as per dwg & Stock Location:

0.00



Packaging

Packaging

Memo

Shelf

0.00

10/07/21

170

QC21- Final Inspection - Work Order Release

0.00



QC

Quality Control

Memo

0.00

At PA4 test.
10.07.22
Conforming
Rec'd PA
10.07.22

MO
10-7-22

Picklist Print

Page 1

July 6, 2010 7:29:12 AM

Work Order ID: 60338



Parent Item: D4102-2



Parent Item Name:

Start Date: 07/07/2010

Required Date: 28/07/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-07-05 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B0.250X04.00 0		Purchased		No			f	16.5000	0.042	0.088421			

6061-T6 Bar .250 x 4.00



Location	Loc Qty	Loc Code
MAT	16.5	
110680	0.5	
114608	16	

.04421 *✓*
.04421 *✓*
10/6/09

POSITIVE RECALL

EFFECTIVE 10.07.06 AUTH U

RELEASED DATE

DART AEROSPACE LTD	Work Order:	60338
Description: Shim	Part Number:	D4102-2
Inspection Dwg: D4102 Rev: DAST		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	<i>SJ</i>	Audited by:	<i>S</i>	Prototype Approval:	N/A
Date:	<i>10/07/15</i>	Date:	<i>10/07/15</i>	Date:	N/A
Rev	Date	Change		Revised by	Approved
A		New Issue		KJ/JLM	

Page #2

DART AEROSPACE LTD	Work Order:	60338
Description: SHIM	Part Number:	04702-2
Inspection Dwg: 04702 Rev: P/A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.356	$\pm .010$.356	✓		VERN	
.490	"	.492	✓		"	
.965	"	.964	✓			
1.344	"	1.344	✓			
2.587	"	2.589	✓			
3.325	"	3.330	✓			
3.370	"	3.377	✓			
3.505	"	3.509	✓			
3.574	"	3.580	✓			
4.000	$\pm .030$	4.011	✓			
4.75	$\pm .030$	4.751	✓			
4.234	$\pm .010$	4.237	✓			
3.940	"	3.942	✓			
3.770	"	3.772	✓			
3.413	"	3.418	✓			
2.315	"	2.318	✓			
2.290	"	2.295	✓			
1.534	"	1.539	✓			
1.125	"	1.128	✓			
.715	"	.720	✓			
.600	"	.602	✓			
.176	$\pm .015$.175	✓		Mics	
.239	$\pm .015$.240	✓		Mics	

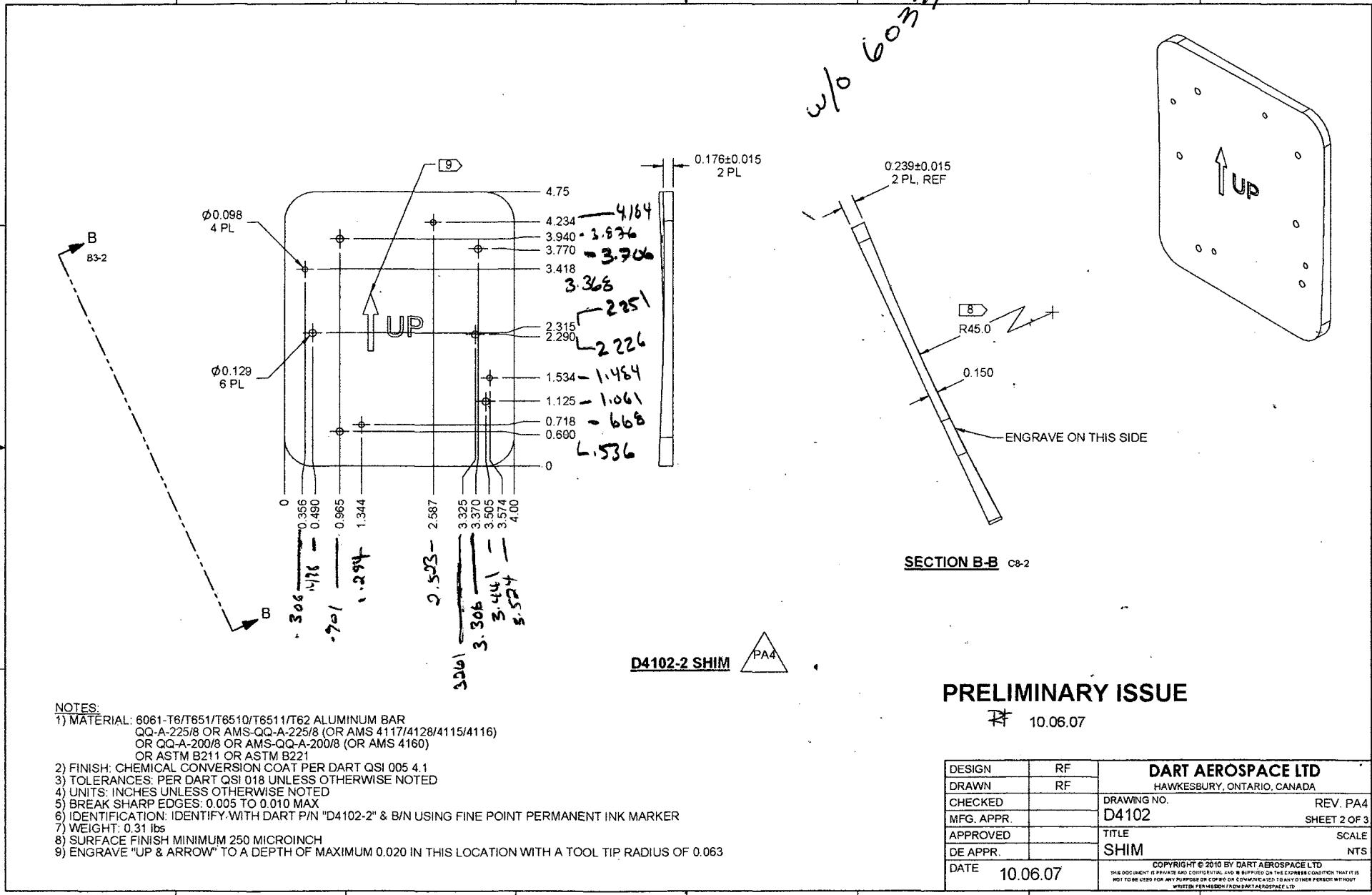
Measured by:	SJ
Date:	10/07/15

Audited by:	S.
Date:	10/07/15 to 004 Day only

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

Page #1



Receiving Report

Date: 9/10/08

Batch No: M110680

Supplier: MCUSA

Dart P/O: Suy5

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No
 Shipment Complete: Yes No
 QES Inspection: Yes No N/A
 Work Order: SL02 Yes No N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Remaining	Quantity Short	Comments
M02024735032		792	0	0	182	
M636176320X060		60	0	0	60	
M63617670632005		108	0	0	108	

Initials of Receiver (If shipment OK) Level 12 CS

Prod/Admin: MIC0617670632005

Date: 09/10/08

Received/Costing: RCP # 10129

Initial: CX

Location:

Dart Aerospace Ltd

Dart Aerospace Ltd
 1270 Aberdeen St
 Hawsbury, Ontario K6A 1K7
 Phone: (613) 632-3336
 Fax: (613) 632-4443

Receiving Slip

Date Feb 3, 2009	Page 1
Receipt Number RCP00010129	

Purchase From:

Magna Stainless
 5775 rue Kieran
 St Laurent, Quebec H4S 0A3
 Canada

Ship To:

Main Finished Goods Location
 Dart Aerospace Ltd
 1270 Aberdeen St
 Hawsbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number VC-MAG002	PO Number PO00008045

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M303R0750	303 Round Bar 0.750 NOTE: AISI 304/316 NOT ACCEPTABLE MATERIAL: AISI 303 ROUND BAR	124.0000 f		3.166666	392.67	Feb 03, 2009
	M6061T6B0250X0	B/N110680 6061-T6 Bar .250 x 4.00 PER AMS-QQ-A-200/8 OR AMS 4150 PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR	20.0000 f		2.650000	53.00	Feb 03, 2009 ✓
	M6061T6T1250W1	B/N110680 ALUM. RD TUBING 1.2 AS ABOVE	160.0000 f		1.150000	184.00	Feb 03, 2009 ✓
	M6061T6T1500W1	B/N110680 6061T6 RD TUBE 1.50 X AS ABOVE	60.0000 f		1.500000	90.00	Feb 03, 2009 ✓
	M6061T6TS1000W	B/N110680 6061T6 SQ TUBE 1.00 x OR AMS 4160 **** FLAT SQUARE EDGE**** AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 SQUARE TUBING PER AMS-QQ-A-225/8 OR	140.0000 f		1.100000	154.00	Feb 03, 2009 ✓
	M304TR0875W065	B/N110680 304 round tube .875 x .0 MAETRIAL: AISI 304/316 SS SEAMLESS ROUND TUBING	120.0000 f		8.750000	1,050.00	Feb 03, 2009 ✓

Comments:

PLEASE DO NOT SHIP ON THE 28TH & 29TH OF JANUARY

I006135

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact:

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Ship Terms: PREPAID

MTR: Y

SPECIAL INSTRUCTIONS

DO NOT SHIP WILL ADVISE
HOLD

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	CHANTAL 8045	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	Date Shipped
W002587	NET 30 DAYS	TARGET	10/23/08	11/21/08	01/28/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
6	X	PC	316L SMLS 7/8" OD .065 X 20' FUEL SURCHARGE	L016423	YTO60922	6
Bundles: 1				Total	Weight:	LB

Received by:

Date:

Signature:

DART

Purchase Order

Date Jan 23, 2009	Page 1
Purchase Order Number PO00008045	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

FAXED
01/23

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 23, 2009	N30	Yours	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
192.0000	M2024T3S032	2024-T3 .032 sheet Comments: MATERIAL: 2024-T3 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037	30/01/2009	No	3.645833	sf	700.00
✓ 120.0000 NCLU 124	M303R0750	303 Round Bar 0.750 Comments: MATERIAL: AISI 303 ROUND BAR NOTE: AISI 304/316 NOT ACCEPTABLE	30/01/2009	No	3.166666	f	380.00
✓ 20.0000	M6061T6B0250X040	6061-T6 Bar .250 x 4.00 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 BAR PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 PER AMS-QQ-A-200/8 OR AMS 4160	30/01/2009	No	2.650000	f	53.00
60.0000	M6061T6B0250X060	6061-T6 Bar .250 x 6.00 Comments: AS ABOVE	30/01/2009	No	4.050000	f	243.00
108.0000	M6061T6T0625W065	6061-T6 RD Tube .625 x . Comments: MATERIAL: 6061-T6 OR 6061-T62 TUBING PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 ***SEAMLESS TUBING***	30/01/2009	No	4.770833	f	515.25
✓ 60.0000	M6061T6T1000W065	6061T6 RD TUBE 1.00 x . Comments: AS ABOVE	30/01/2009	No	5.320833	f	319.25
✓ 160.0000	M6061T6T1250W125	ALUM. RD TUBING 1.250 Comments: AS ABOVE	30/01/2009	No	1.150000	f	184.00
✓ 60.0000	M6061T6T1500W125	6061T6 RD TUBE 1.50 X . Comments: AS ABOVE	30/01/2009	No	1.500000	f	90.00
✓ 140.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x 1 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62	30/01/2009	No	1.100000	f	154.00

1/23/09
MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

1/30/09
1/30/09

Continued on next page...

DART

Purchase Order

Date Jan 23, 2009	Page 2
Purchase Order Number PO00008045	

Dart Aerospace Ltd
1270 Aberdeen St
Hawsbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Magna Stainless
5775 rue Kieran
St Laurent, Quebec H4S 0A3
Canada
Phone (514) 339-1211
Fax (514) 339-1105

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawsbury, Ontario K6A 1K7

Reference	Contact	Vendor Number	PO Date	Terms	Ship Via	Expected Arrival
		VC-MAG002	Jan 23, 2009	N30	Yours	Jan 30, 2009

Qty. Ordered	Item Number	Description	Expected Arrival	Drop-SHIP	Unit Cost	UOM	Extended Price
80.0000	M304TR0875W065	SQUARE TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160 **** FLAT SQUARE EDGE**** Comments: MATERIAL: AISI 304/316 SS SEAMLESS ROUND TUBING	30/01/2009	No	8.750000	f	700.00
12.0000	M7075T6B1500X150	304 round tube .875 x .065 30/01/2009 No Comments: MATERIAL: 7075-T6 BAR 1.500 x 1.5 30/01/2009 No PER AMS-QQ-A-225/9 OR AMS 4122/4123/4186/4187 OR PER AMS-QQ-A-200/11	30/01/2009	No	16.500000	f	198.00

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Comments:

PLEASE DO NOT SHIP ON THE 28TH & 29TH OF JANUARY

Tax Summary:
GST
ONTPST

176.83
0.00

Less:
included tax

0.00

Subtotal

3,536.50

Total tax

176.83

Total purchase order in

CAD Dollars

3,713.33

Entered By: CLAVOIE

Approved By:

ANALYSIS CERTIFICATE

Empire Resources, Inc.

One Parker Plaza
Fort Lee, NJ 07024-2937
United States
Tel : (201) 944-2200
Fax : (201) 944-2226
dfike@empireresources.com

EMPIRE Letter Ref # : EWR44185



Monday, 28 April, 2008

S
07/02/02

Date : April 28, 2008

Sales Contract # : E131500

Alloy-Temper : 6061-T6

Container # : EXTR20080414

Case # : EXC16740

Cast # : 18836

Die # : A10023

Specification : .250" X 4" X 20' FLAT BAR 6061, T6

Purchase Order : 073349-AD1

Customer Part # :

MADE IN THE USA

Chemical Composition (WT%)

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other Elements
Min	0.40		0.15		0.8	0.04		Each Max Total Max
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15
Actual	= 0.6	= 0.22	= 0.21	= 0.07	= 0.87	= 0.06	= 0.02	= 0.017 = 0

* Aluminum = Remainder

Actual cast analysis is retained on file.

Tensile Properties

Test No.	Yield (ksi)	Tensile (ksi)	Elong. (%)
1	36.3	38.2	16.3

ASTM B221-06. AMS-QQ-A-200/8-97

Authorized Signature

Ross Toombs
General Manager

Page 1 of 1

C G 155

Receiving Report

Date: 10/5/08

Supplier: M26VA

Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

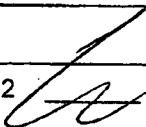
Batch No: M114608

Dart P/O: 11792

Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection N/A N/A
 Work Order 10/5/08 N/A

Discrepancies

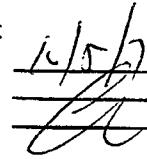
Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 

Production/Admin:

Date 10/5/08

Received/Costing

Initial 

Location

MAGNA

INOXYDABLE

Magna Stainless

5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 339-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105



PACKING LIST

Page 1 of 1

SOLD TO
DART AEROSPACE LTD
1270 ABERDEEN STREET

SHIP TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

HAWKESBURY , ON
K6A 1K7

SPECIAL INSTRUCTIONS

Currency	Sales Person	Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS	ERYCK BLAIS	(613) 632-5200	(613) 632-1053	PO11792	
Sales Order	Terms	Ship Via	Date Ordered	Date Required	
W029143	NET 30 DAYS	NTR-R-557065-1	05/03/10	05/06/10	05/06/10

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
1		PC	ALUMINUM FLATS AFL 6061 T6 1/4" x 4" x R/L 46' 19 LB / 1 PC	L038946	19249	1
1		PC	AFL 6061 T6 1-1/2" x 2" x R/L 12' 43 LB / 1 PC	L038947	20304268	1
					6/2/5/6	1

Received by: _____ **Date:** _____ **Signature:** _____

ANALYSIS CERTIFICATE

Empire Resources, Inc.

One Parker Plaza
Fort Lee, NJ 07024-2937
United States
Tel : (201) 944-2200
Fax : (201) 944-2226
tiehr@empireresources.com

ND 30924

EMPIRE Letter Ref # : EWR55924

EWR55924

Monday, 29 March, 2010

Date : March 29, 2010

Sales Contract # : E141131

Alloy-Temper : 6061-T6

Container # : EXTR20080611

Case # : EXC19165

Cast # : 19249

Die # : A10023

Specification : .250" X 4" X 16' RECT BAR 6061, T6

Purchase Order : P003974

Customer Part #:

10/05/10

PC 10016 - 1A2MA

MADE IN THE USA

Chemical Composition (WT%)

Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Other Elements	
Min	0.40		0.15		0.8	0.04			
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	Each Max Total Max
Actual	= 0.58	= 0.2	= 0.19	= 0.04	= 0.83	= 0.05	= 0.01	= 0.015	= 0

* Aluminum = Remainder

Actual cast analysis is retained on file.

Tensile Properties

Test No.	Yield (ksi)	Tensile (ksi)	Elong. (%)
1	35.6	38.6	16

ASTM B221-06 AMS-QQ-A-200/B-97



Authorized Signature

Ross Toombs
General Manager

Page 1 of 1

C 4905